

Work Order ID 80563

February-23-12 11:18:44 AM

up March 10

80563

Page 1

Item ID: D4526-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Maintenance Step Assembly

Start Date: 23/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/23 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4526	A								
100	Pick Kit	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg Torque screws up to 15-25 in- lbs								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

ES 12/03/14 (4)

ES 12/03/14 (4)

(40)

5.2/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80563***80563***

Page 2

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Item Name: Maintenance Step Assembly

Start Date: 23/02/2012 Start Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

PAP 80561

0.00

Packaging

12/3/14 (4)

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

*MCJ 12/03/15**12-03-15*

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 80563

80563

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No			100	Each	1.0000	2	8			
D4092-1									**				
Maintenance Step													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST241A	1							
					74303	1							
D4526-043		Manufactured	No			100	Each	0.0000	1	4			
D4526-043									**				
Tube Assembly													
D4527-1		Manufactured	No			100	Each	1.0000	1	4			
D4527-1									**				
Bracket													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					st139h	1							
					77209	1							
D4527-3		Manufactured	No			100	Each	11.0000	1	4			
D4527-3									**				
Bracket													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					st139h	11							
					77208	1							
					80086	10							

12/03/14
 B77852
 B80564
 12/03/14
 B80087
 12/03/14
 B80088
 12/03/14

W/O:		WORK ORDER CHANGES					
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Page 2

Work Order ID: 80563

Parent Item: D4526-042

Parent Item Name: Maintenance Step Assembly

80563

D4526-042

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

100

Each

4,190.000

10

40

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

4190

117441

16

117885

32

118451

5

118927

3

119017

3862

119075

272

40

MS24694-S55

Purchased

No

100

Each

125.0000

8

32

MS24694-S55

Screw

**

Location

Loc Qty

Loc Code

ST289A

125

119307

49

120142

76

32

MS24694-S75

Purchased

No

100

Each

23.0000

2

8

MS24694-S75

Screw

**

Location

Loc Qty

Loc Code

GA

23

119892

23

8

W/O:		WORK ORDER CHANGES					
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Work Order ID: 80563

80563

Parent Item: D4526-042

D4526-042

Parent Item Name: Maintenance Step Assembly

Start Date: 23/02/2012

Required Date: 05/03/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

100

Each

2,359.000

10

40

NAS1149D0332.J

Washer

**

Handwritten signature and date: 2/03/14

Location

Loc Qty

Loc Code

ST298

2359

105793

12

110985

4

117087

89

119042

284

119717

970

120644

1000

Handwritten number: 40

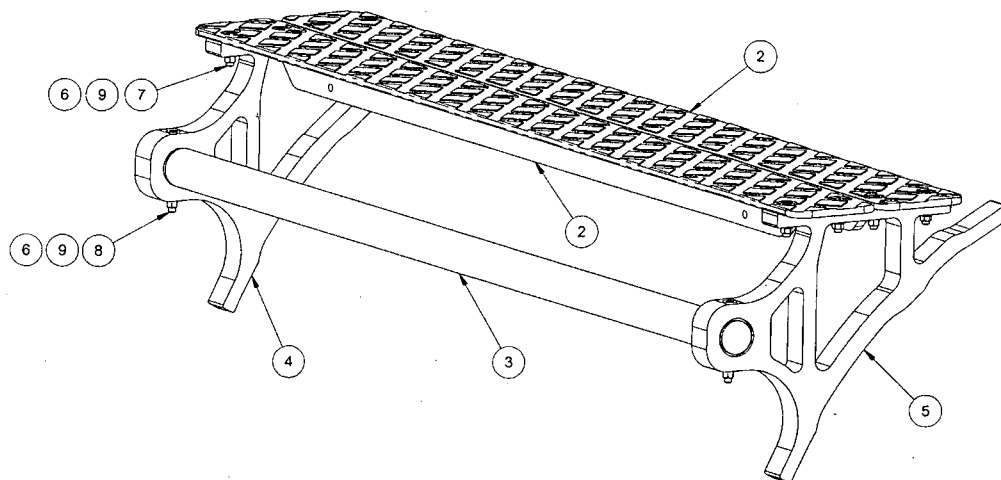
W/O:		WORK ORDER CHANGES					
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D4526-042 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D4526-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4526-043	TUBE ASSEMBLY
4	1	D4527-1	BRACKET
5	1	D4527-3	BRACKET
6	10	MS21042L3	NUT
7	8	MS24694-S55	SCREW
8	2	MS24694-S75	SCREW
9	10	NAS1149D0332J	WASHER

SECURITY
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 UNCONTROLLED COPY
 SUBJECT TO AGREEMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. **80563 M.C.J**
12/02/23

RELEASED
 2011-11-28
 JAW

A	NEW ISSUE	RF	11.11.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.11.22		

DART AEROSPACE USA, INC. KENT, WA		REV. A
DRAWING NO.	D4526	SHEET 1 OF 5
TITLE	MAINTENANCE STEP ASSY	SCALE NTS
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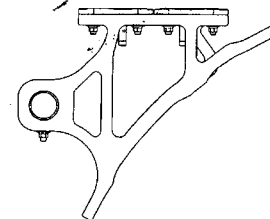
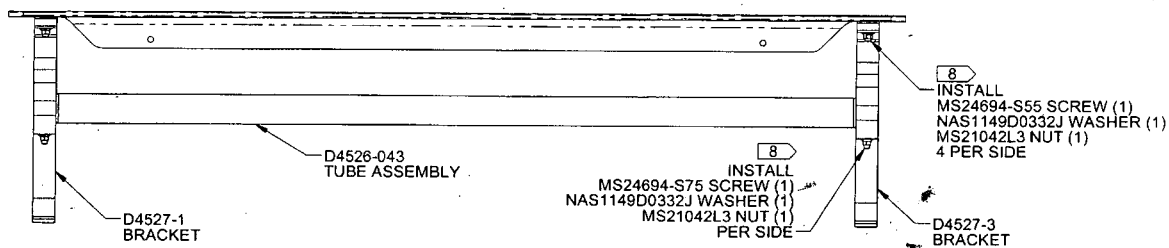
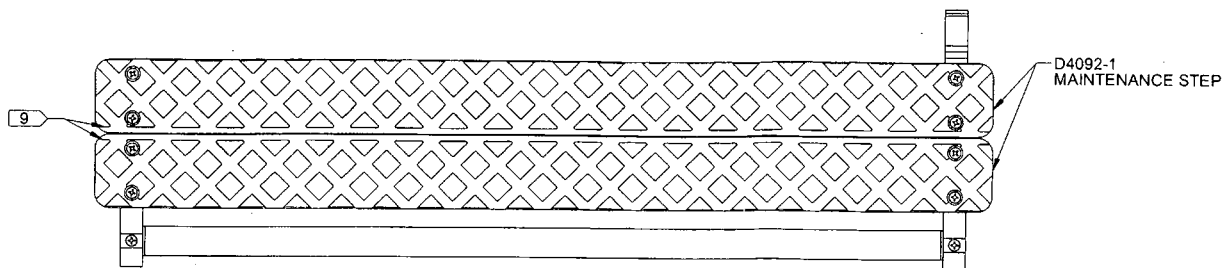
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4526-042 MAINTENANCE STEP ASSEMBLY

RELEASED
2011-11-28
WPD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 7.09 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

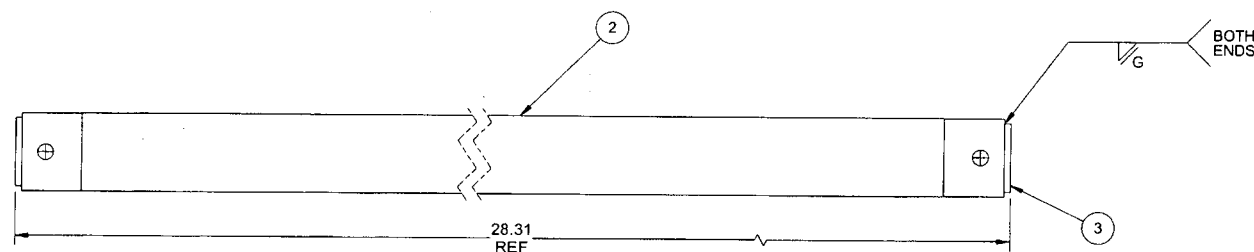
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NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4526-043	TUBE ASSEMBLY
2	1	D4526-1	TUBING
3	2	D4526-3	CAP

80563



D4526-043 TUBE ASSEMBLY

RELEASED
2011-11-28
ND

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 1.32 lbs
- 8) WELD PER QSI 004

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

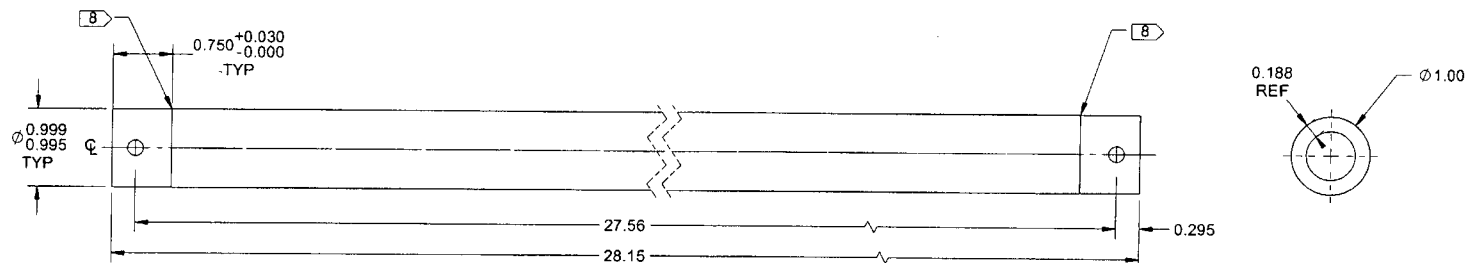
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NOTE: Date & initial all entries

80563



D4526-1 TUBING

RELEASED
R 2011-11-28
AM

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
REF DART SPEC M6061T6T1.000W.188
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs
- 8) MIN RADIUS OF TRANSITION OF R0.06

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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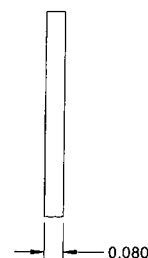
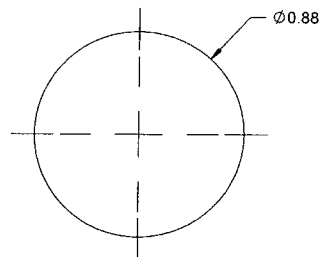
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80563



D4526-3 CAP

RELEASED
2011-11-28

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.005 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
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MFG. APPR.	<i>[Signature]</i>	D4526	SHEET 5 OF 5
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